

Work Order ID 123152

Tuesday, July 29, 2014 2:32:41 PM

123152

Page 1

Item ID: D2661-2

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, RH, Fwd, Aft, Out

Start Date: 7/29/14 Start Qty: 5.00 ***5***

Cust Item ID:

Required Date: 7/29/14 Req'd Qty: 5.00 ***5***

Customer:

Reference:

Approvals: Process Plan: J. A Date: 14/07/30 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2661	Rev E

100

0.00

100

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number
MACHINE AS PER DWG AND FOLIO FB071FOLIO REV: AA
DWG REV: E

S ϕ _____ hwp

110

0.00

110

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

S ϕ _____ hwp

DAS

44 14/09/18
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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DQA: _____ Date: _____



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Work Order ID 123152

Tuesday, July 29, 2014 2:32:41 PM

123152

Page 4

Item ID: D2661-2 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle, RH, Fwd, Aft, Out
Start Date: 7/29/14 Start Qty: 5.00 ***5*** Cust Item ID:
Required Date: 7/29/14 Req'd Qty: 5.00 ***5*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

MLJ 14-09-24

MF
14-9-24

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>
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Picklist Print

Tuesday, July 29, 2014 2:32:41 PM

Page 1

Work Order ID: 123152

123152

Parent Item: D2661-2

D2661-2

Parent Item Name: Saddle, RH, Fwd,Aft, Out

Start Date: 7/29/14

Required Date: 7/29/14

Start Qty: 5.00

Required Qty: 5.00

Comments:

IPP: C00.11.01Removed P/O for Powder Coat - in house
processEC

IPP REV:D

REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD

IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003		Manufactured	No			100	Each	37.0000	1	5			

D6101-003

Saddle Billet, 7075

Location

Loc Qty

Loc Code

MAT040

18

115091

18

MAT044

13

120394

13

MAT045

6

114314

6

122325

Sx DFC 2014-09-11

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

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Handling/Pre									
Material									
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FAULT CATEGORY

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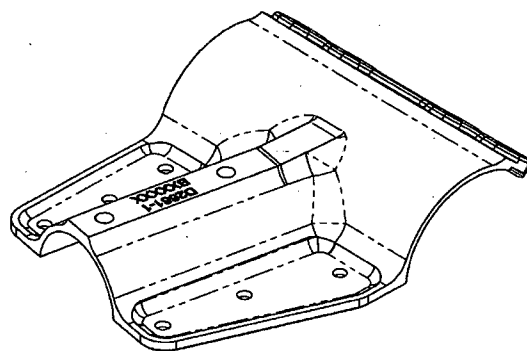
DART AEROSPACE LTD		Work Order:	123 152
Description: 206 Saddle, Outboard, Right side		Part Number:	D2661-2
Inspection Dwg: D2661	Rev: E	DSK:	Rev:
			Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

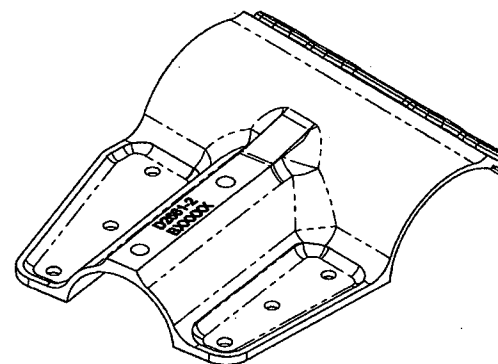
Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	3.611	3.621		3.615	3.615	3.615	3.615	3.615
B	0.256	0.263		0.259	0.259	0.259	0.259	0.259
C	0.315	0.322		0.317	0.317	0.317	0.317	0.317
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	1.357	1.367		1.362	1.362	1.362	1.362	1.362
G	0.100	0.140		0.127	0.127	0.126	0.126	0.126
H	0.210	0.230		0.227	0.227	0.227	0.227	0.227
I	0.615	0.685		0.680	0.680	0.680	0.680	0.680
J	2.470	2.510		2.490	2.490	2.490	2.490	2.490
K	1.313	1.343		1.327	1.328	1.327	1.327	1.327
L	0.178	0.198		0.188	0.188	0.188	0.188	0.188
M	0.470	0.530		0.500	0.500	0.500	0.500	0.500
N	1.125	1.145		1.138	1.138	1.137	1.136	1.137
O	0.100	0.180		0.120	0.120	0.120	0.120	0.120
P	0.100	0.140		0.131	0.128	0.130	0.130	0.130
Q	0.240	0.260		0.252	0.253	0.253	0.253	0.252
R	0.677	0.697		0.687	0.687	0.687	0.687	0.687
S	0.100	0.140		0.127	0.126	0.127	0.127	0.127
T	1.565	1.585		1.578	1.571	1.570	1.570	1.573
U	0.540	0.560		0.550	0.550	0.550	0.550	0.550
V	0.912	0.932		0.925	0.925	0.925	0.925	0.925
W	0.787	0.807		0.795	0.795	0.795	0.795	0.795
X	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Y	4.995	5.005		5.000	5.000	5.000	5.000	5.000
Z	0.490	0.510		0.500	0.500	0.500	0.500	0.500
AA	0.312	0.319		0.313	0.313	0.313	0.313	0.313
AB	0.990	1.010		1.007	1.007	1.007	1.007	1.007
AC	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AD	0.490	0.510		0.505	0.505	0.505	0.505	0.505
AE	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AF	0.235	0.240		0.239	0.239	0.239	0.239	0.239
AG	0.510	0.515		0.511	0.511	0.511	0.511	0.511
AH	0.100	0.120		0.114	0.116	0.115	0.115	0.115
Accept/Reject				✓	✓	✓	✓	✓

Measured by:	<i>[Signature]</i>	Date:	14/08/17
Audited by:	<i>[Signature]</i>	Date:	14/09/18
Prototype Approval:	9-89	Date:	

Rev	Date	Change	Revised by	Approved
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	<i>[Signature]</i>



D2661-1 SADDLE, OUTSIDE, LH

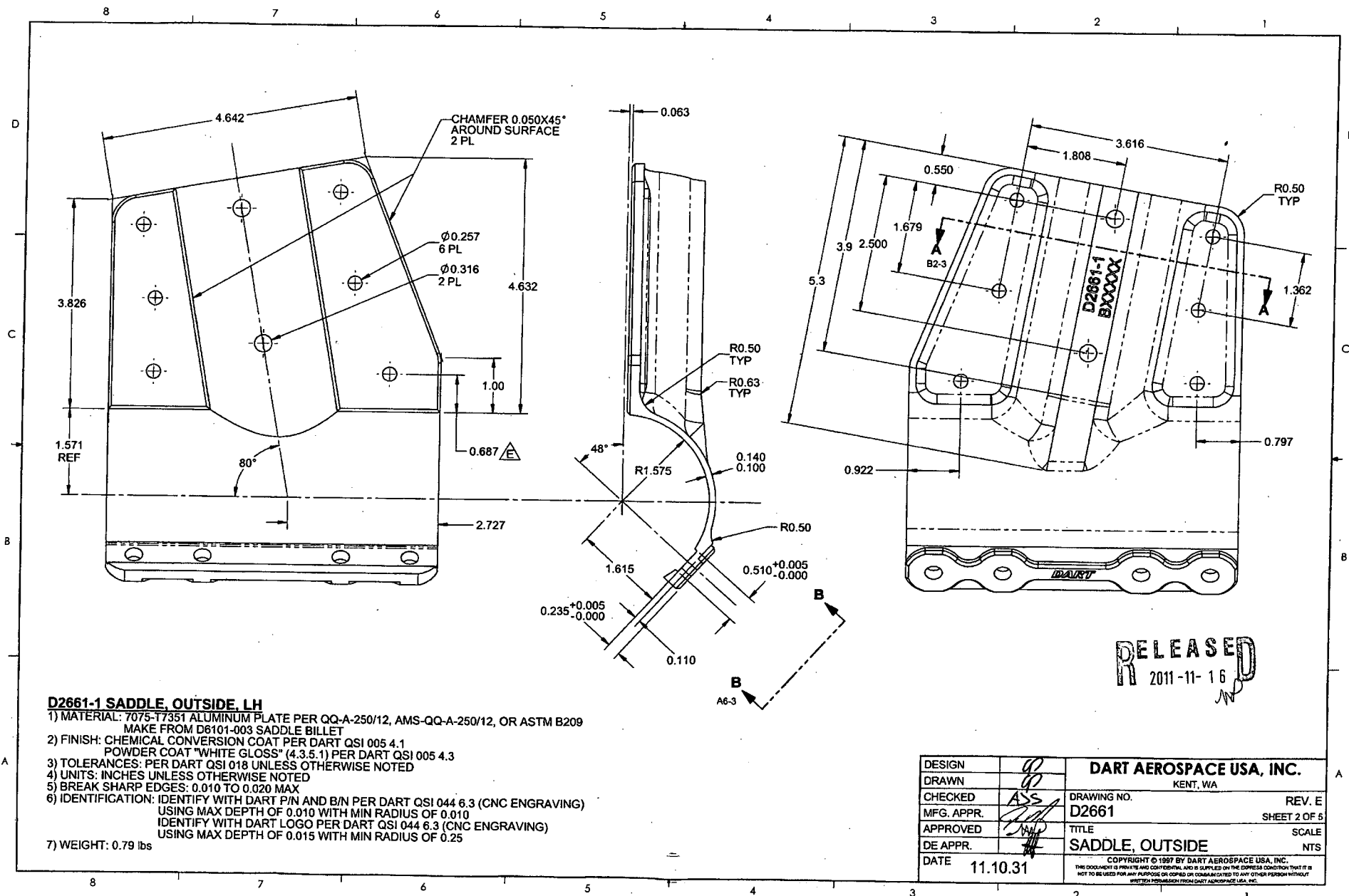


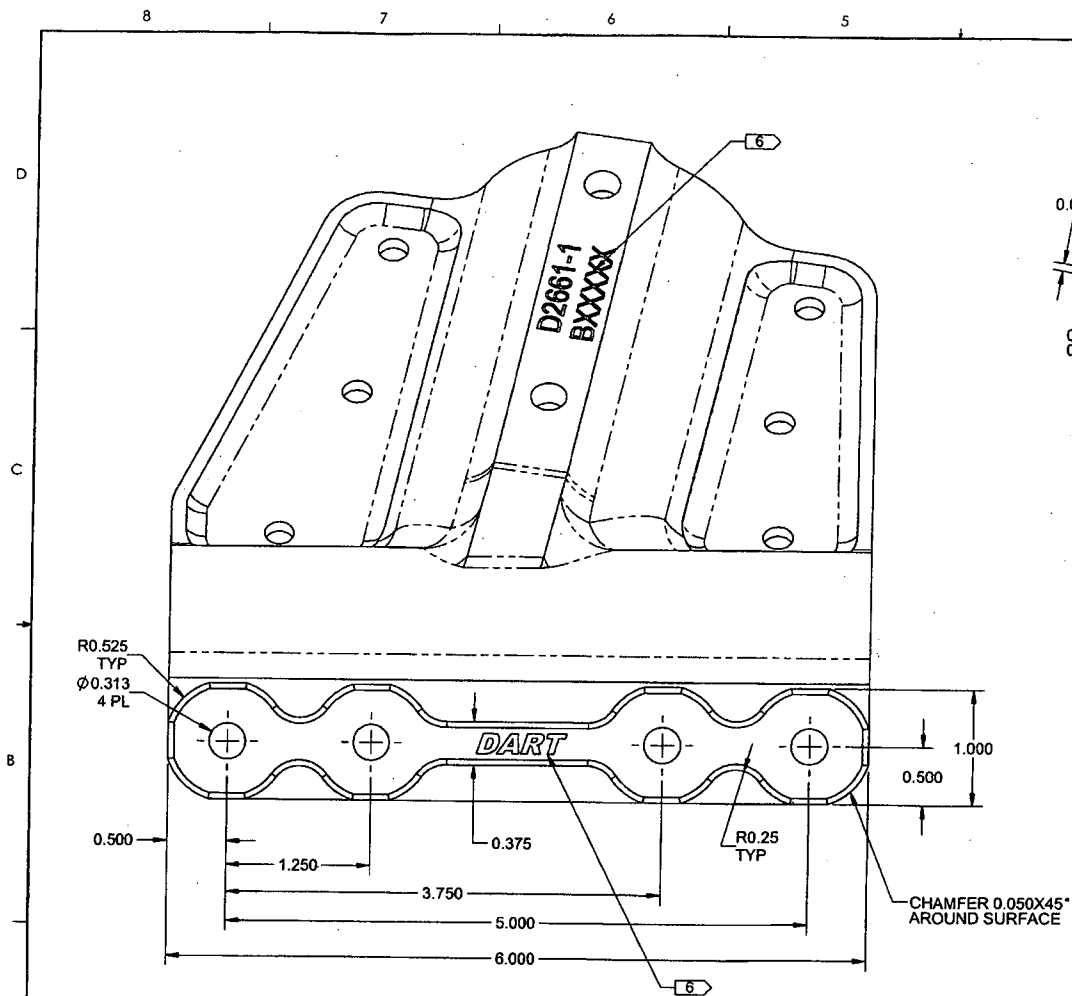
D2661-2 SADDLE, OUTSIDE, RH

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2011-11-16

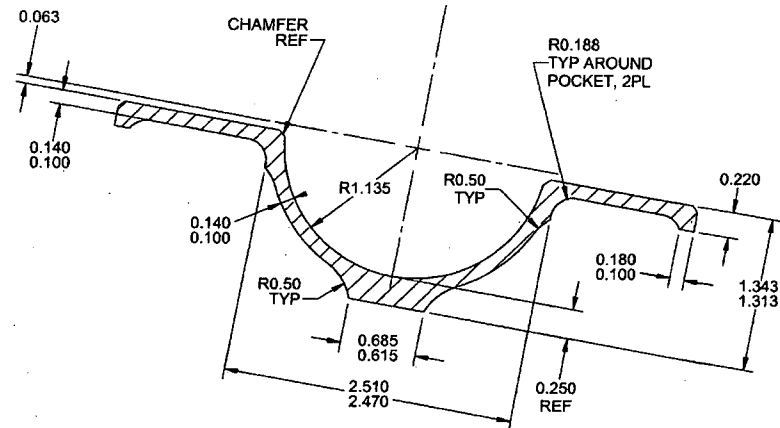
J.A 14/07/30 123152

REV.	DESCRIPTION	BY	DATE
E	REDRAW & REFORMAT DWG; 0.687 WAS 0.547 (B6-2,B8-4), REF INCR 11-935	CP	11.10.31
D	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	CB	06.11.08
C	INCORPORATE DEO 8122, 8102, 9085	CB	06.05.29
B	ANGLE AND NOTES ADDED	KE	97.07.11
A	NEW ISSUE	DS	07.03.25
DESIGN	DART AEROSPACE USA, INC.		
DRAWN	KENT, WA		
CHECKED	DRAWING NO. D2661		
MFG. APPR.	REV. E		
APPROVED	SHEET 1 OF 5		
DE APPR.	TITLE		
DATE	SADDLE, OUTSIDE		
11.10.31	NTS		
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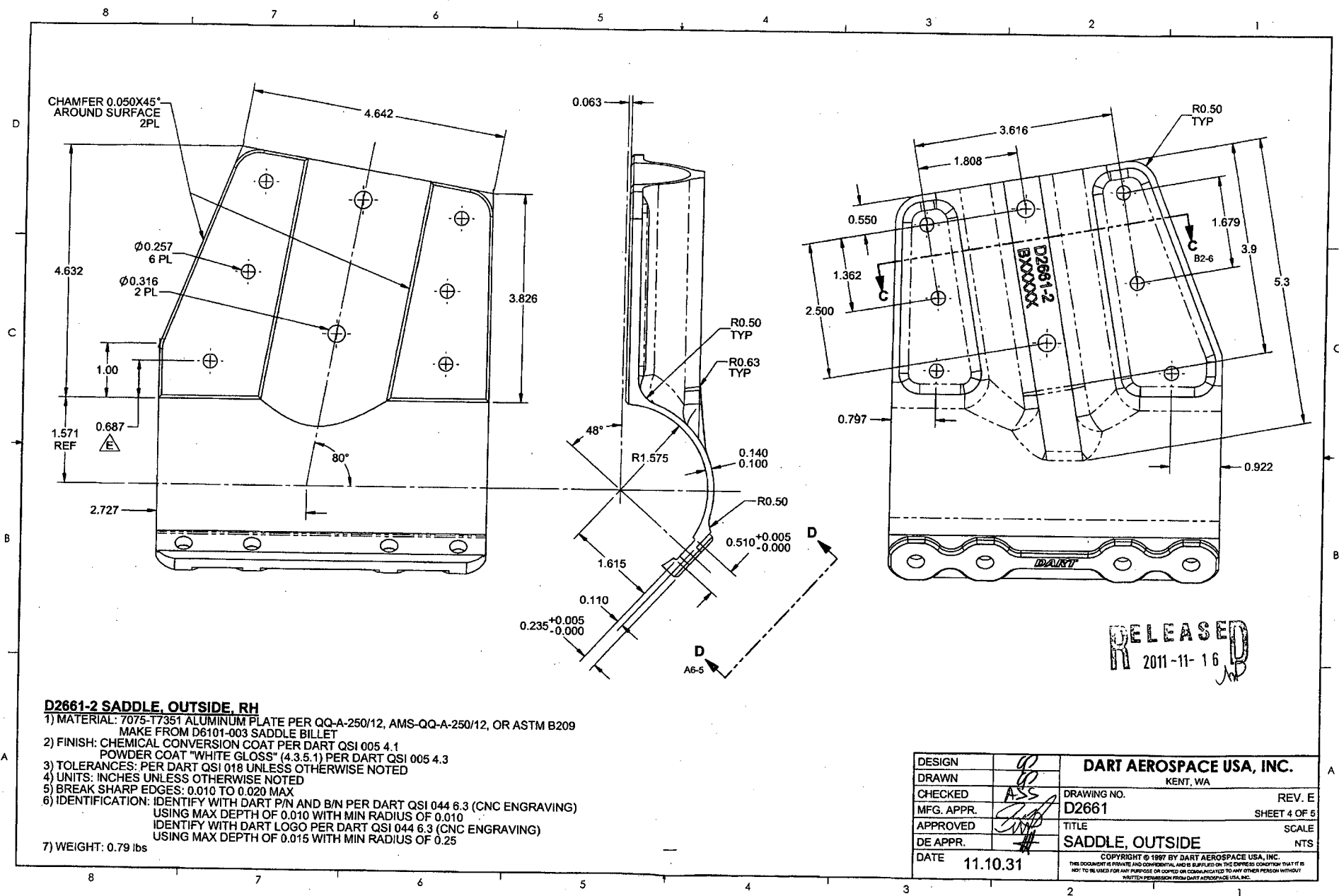
VIEW B-B
SCALE 1.5X A4-2
VIEW ROTATED

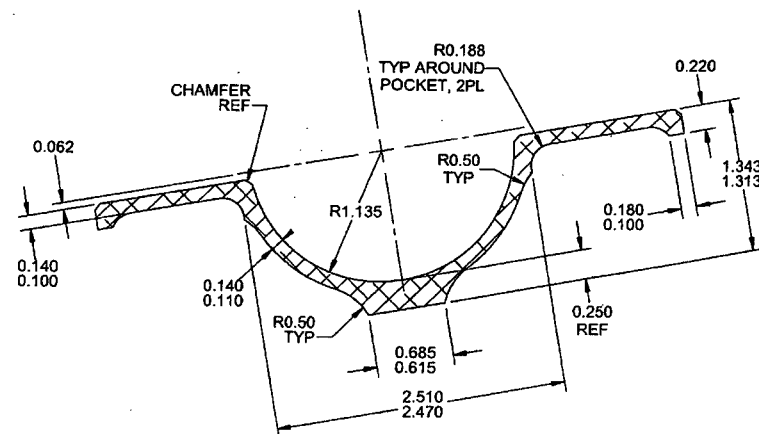
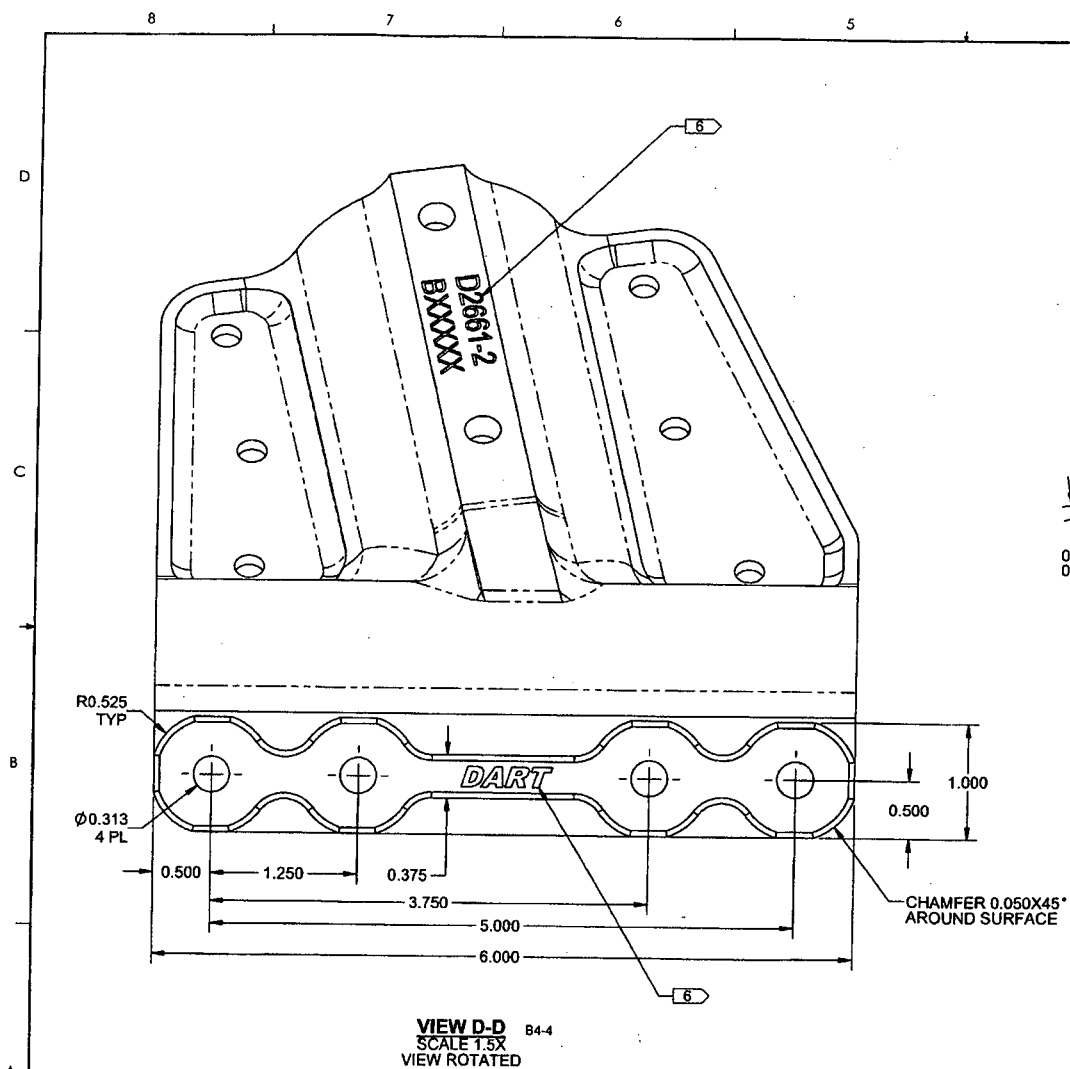


VIEW A-A
SCALE 1.5X C3-2

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MFG. APPR.		TITLE	SHEET 3 OF 5
APPROVED		SADDLE, OUTSIDE	SCALE
DE APPR.			NTS
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